

Work Order ID 70737

Tuesday, June 14, 2011 9:23:11 AM



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Item ID: D2940-1

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Support

Start Date: 6/14/2011 Start Qty: 21.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 21.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2940

Rev B U/R

130

~~White Gloss (Ref 4.3.5.2) per QSI005 4.3-Steel~~

0.00



Powdercoat

Memo

0.00

Powder Coating

PULL FROM STOCK:

20 X D2940-1 B68373 x20

1 X D2940-1 B60271 x1

STRIP PAINT COMPLETELY PER U/R FORM 11/06/13

11 06 13 20

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 06 21

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Start Date: 6/14/2011 Start Qty: 21.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 21.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: *K tube*

0.00



Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

*85**11-06-21**(Y21)*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/6/21**me**11-06-21*

Picklist Print

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Work Order ID: 70737



Parent Item: D2940-1



Parent Item Name: Support

Start Date: 6/14/2011


Required Date: 6/17/2011

Start Qty: 21.00

Required Qty: 21.00

Comments:

IPP C 02.11.26 Reformat; Added P/O KJ
IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD
IPP Rev:F 08-10-22 add qc14 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2940-1  Support | | Manufactured | No | | | | Each | 0.0000 | | 21 | | | |

68373 x 20
60271 x 1



21 11-06-17

Under Review Notification

Raised By: Chris Provencal

Date: 11.06.13

Product #: 667, 676, and 664

Product Name: crosstubes

| Drawing/Kit Number | Drawing/Kit Description | Quantity on Hand (Stock) | Quantity on Order (Production) | Quantity Allocated (Customer Order) | HOLD SHIPMENT | Red Tag/Quarantine Stock | Advise customers | Stop Production | Re-Work Stock | IPP Under Review | Blue File Under Review | ECN # | Instructions |
|-----------------------|----------------------------|--------------------------|-----------------------------------|--|---------------|--------------------------|------------------|-----------------|---------------|------------------|------------------------|-------|--------------|
| D2891-1 | Support | | | | Y | Y | N | Y | Y | Y | Y | | |
| D2892-1 | Support | | | | Y | Y | N | Y | Y | Y | Y | | |
| D2893-1 | Support | | | | Y | Y | N | Y | Y | Y | Y | | |
| D2940-1 | Support | | | | Y | Y | N | Y | Y | Y | Y | | |
| D212-664-141 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D412-664-145 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D212-664-147 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D212-664-241 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D212-664-247 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D206-667-141 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D206-667-143 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D407-667-145 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D206-667-147 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D206-667-241 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D206-667-243 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D206-667-247 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D058-676-141 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |
| D058-667-241 | Crosstube | | | | Y | Y | N | Y | Y | Y | Y | | |

Description of issue:

- Process to bond supports onto crosstube is changing
- Finish on supports and xtube will change
- Get new process instructions from ENG prior to making more xtubes
- Modified crosstubes will need a new CHG number

| Item ID | Item Name | Lot Qty | Lot Nbr |
|---------|---------------|---------|---------|
| D2891-1 | 2.25 Support | 9 | 53773 |
| D2891-1 | 2.25 Support | 20 | 68522 |
| D2892-1 | Support | 14 | 42785 |
| D2892-1 | Support | 14 | 68808 |
| D2892-1 | Support | 2 | 70115 |
| D2893-1 | 2.75 Support | 15 | 69713 |
| D2893-1 | 2.75 Support | 5 | 69713 |
| D2893-1 | 2.75 Support | 1 | 68799 |
| D2894-1 | 2.750 Support | 4 | 66702 |
| D2894-1 | 2.750 Support | 4 | 43881 |
| D2896-1 | Support | 11 | 67742 |
| D2940-1 | Support | 20 | 68373 |
| D2940-1 | Support | 1 | 60271 |

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Wednesday, June 15, 2011 3:05 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'; 'Linda Lacelle'
Subject: RE: Procedure for installing supports.

Hi Chris,

I agree with your procedure outlined below. It is our preference to leave the paint on the crosstube if we can for added corrosion protection (and for ease of manufacture). If Dan's final testing shows there is a big difference between a painted/unpainted crosstube, then we will switch to alodine only on the crosstube.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, June 15, 2011 11:24 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'
Subject: RE: Procedure for installing supports.

David,

Can I confirm that this is the agreed procedure for all newly manufactured tubes with off-center supports:

- Scuff paint under support, clean with MEK
- Completely remove any finish on support (if present), scuff bottom surface of support, clean with MEK
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Let cure for 72 hours after installation, recheck torque.

Chris

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: Tuesday, June 14, 2011 10:59 AM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'
Subject: RE: Procedure for installing supports.

Made a couple of small changes.

- Remove finish on xtube in area of support down to alodine finish.
- Touch up alodine on xtube in affected area
- Completely remove any finish on support, scuff bottom surface of support
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Touch up paint finish as req'd per QSI 005
- Let cure for 72 hours after installation, recheck torque.